

Date: Wednesday, 2/15/2006 3:44:57 PM  
 User: Kim Johnston

## Process Sheet

*Split*  
*JB 06/05/16*

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PILOT/CO-PILOT STEP, LH (FOLDING)
<b>Job Number</b> : 25821	
<b>Estimate Number</b> : 12026	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D412630023
<b>This Issue</b> : 2/15/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D412-630 REV. J, P13
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : J
<b>Previous Run</b> : 22511	<b>Material</b> : N/A
	<b>Due Date</b> : 3/20/2006
<b>Written By</b> : <i>See comment below</i>	<b>Qty</b> : <i>5</i> <b>Um</b> : Each
<b>Checked &amp; Approved By</b> : <i>JB 06-02-16</i>	
<b>Comment</b> : Est. Rev. LB 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM	

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-023 CHG002

*DH 06/03/15*

2.0 D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

*25483*

3.0 D2803041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

*B25917*

4.0 D2804041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

*B25915*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 2/15/2006 3:44:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

25247

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B26649

7.0

D3388041

Step Weldment LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3388-041	Step Weldment LH

Batch

B266527

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B25935

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

MLR515

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 2/15/2006 3:44:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M18515

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M18779

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M100218

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 2/15/2006 3:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100050

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M100446

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

SAN

06:06:12

2

19.0

QC5

INSPECT WORK TO CURRENT STEP



06.06.12 2

Comment: INSPECT WORK TO CURRENT STEP

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Wednesday, 2/15/2006 3:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-1

Description

Bushing

Batch

B25921 x 7 B25863 3X

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

B25922 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

B23631 2 ✓  
B23631 B26758 x 3 ✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

B26758 x 3 B24645 ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C6A

Description

Bolt

Batch

B19512 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 2/15/2006 3:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

M18515 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

M19600 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN44-C7A	Eyebolt

Batch

M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

M18167 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~16.0000~~ Each(s)

Nut

Pick: Packing Kit

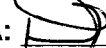
Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M100651 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 2/15/2006 3:44:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 25821

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: ~~12~~.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

MR535 ✓

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: ~~28~~.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H4

Description

Washer

Batch

MR535 x 70, M100680 x 11

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

MR535 x 10, M19565 x 14

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-023

Location:

PPP Rev:

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

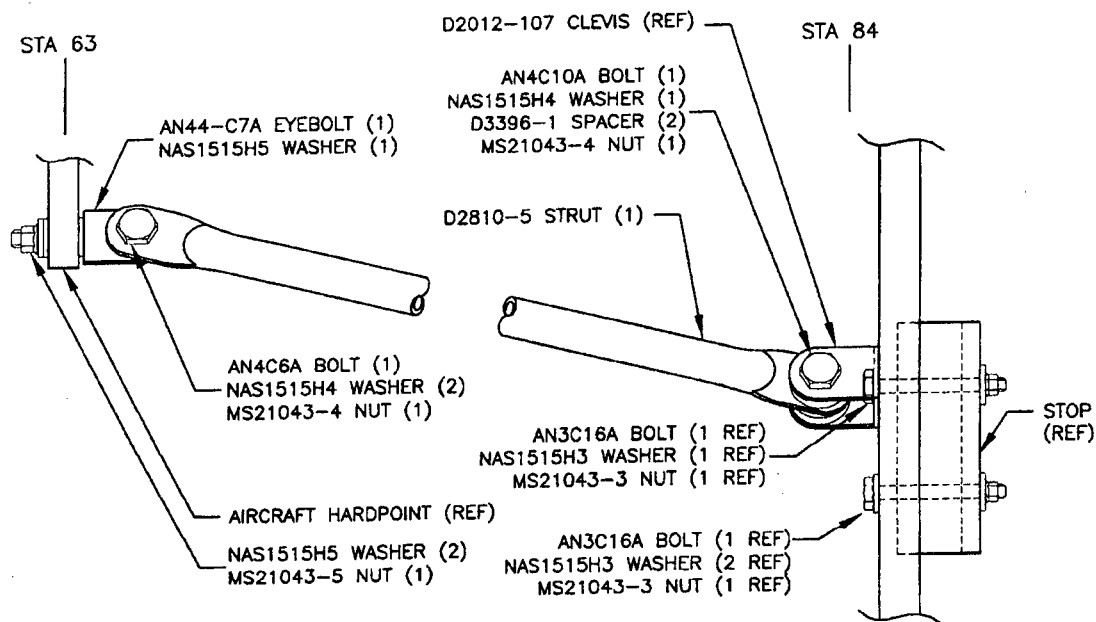
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step™* Installation  
(NOT TO SCALE)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25821

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: J  
Date: 05.12.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_